Date: Monday, 16/03/2009 9:16:23 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 46500
Estimate Number : 12472
P.O. Number :
This Issue : 16/03/2009 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : SKIDTUBES
Previous Run : 42526
Written By :
Checked & Approved By : JLD 09-03-16
Comment : Est Rev:A 06-06-21 New Issue JLM
Est Rev:B 06-12-18 As per Rev B JLM
Est Rev:C 07-12-11 ECN 1036 as per revB DD
Est Rev D 08.11.04 Added DT9431 to sequence 5 EC
vcerified DD

Drawing Name : EC 135 SKIDTUBE ASSEMBLY
Part Number : D135751011
Drawing Number : D3507 REVC
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 31/03/2009 **Qty:** 1 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

for JLD 08/04/09

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP D135-751-011 CHG001

8 08/04/09 (1)

2.0	D2962150	3.540 Outer Tube, Extrut

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2962-150 Extrusion 328622

9-3-16

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

09-03-16 (1)

4.0	BENDING	BENDING MACHINE - SKIDTUBES

Comment: BENDING MACHINE

09-03-16 (1)

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 9:16:23 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** EC 135 SKIDTUBE ASSEMBLY

Job Number: 46500 **Part Number:** D135751011

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185

2-Cut Aft end at VC using DT8185

3-Deburr ends M 9-3-17

4-Drill Aft &Fwd Cap holes using DT8678 M

5-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with 3/16cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using 3/16" drill.****DO NOT OPEN AFT CAP HOLES*****

M 9-3-17

7-Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3507.

9-Open holes section C-C to .375" and locate DT9431 using "T" pin & cleco.

10- Drill holes section G-G (DT9431)

11-Open Aft & Fwd Cap holes using .208" drill.

12-Bore out aft end of tube as per Dwg D3507 & Detail "B".

13-Open ground wire hole .297" section E-E

14-Deburr holes.

9-3-17

6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

09/03/17

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

09-03-17

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 9:16:23 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** EC 135 SKIDTUBE ASSEMBLY

Job Number: 46500 **Part Number:** D135751011

Job Number:

Seq. #:	Machine Or Operation:	Description :
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION D M 9-3-19

9.0 D35043 Crossbolt Spacer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CROSSBOLT SPACER
Batch: B 31232 BF 09-03-19

10.0 D35041 Crossbolt Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
CROSSBOLT SPACER
Batch: B 31234 BF 09-03-19

11.0 D35051 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEB
Batch: B46541 M 09-03-19 (1)

12.0 D35061 Doubler

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
DOUBLER
Batch: B46538 (4) M 9-3-19

13.0 D35063 Doubler

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
DOUBLER
Batch: B46539 (2) M 9-3-19

14.0 D35045 Crossbolt Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
CROSSBOLT SPACER
batch B 36181 BF 09-03-19

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 9:16:23 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** EC 135 SKIDTUBE ASSEMBLY

Job Number: 46500 **Part Number:** D135751011

Job Number:

Seq. #:	Machine Or Operation:	Description :
15.0	MS20601AD4W3	Rivet

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Rivet
Batch: M107823 M 9-3-19

16.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015
A/R 241 Sike Flex Batch: M109883
Exp Date: 09-07-11

09-03-18

5-Weld x-bolt (D3504-1/-3)spacers as per Dwg D3507 and Detail C-C & D-D.
A/R AL ROD Batch: M109213 AE 09/03/19

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

9-3-19

8-Deburr Rivet holes.

Tools: E

17.0	QC10	VISUAL INSPECTION OF GROUND WELDS

Comment: VISUAL INSPECTION OF GROUND WELDS PD 09-03-23

18.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Rivet D3506-1/-3 as per Dwg D3507. 09-03-23

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 9:16:23 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** EC 135 SKIDTUBE ASSEMBLY

Job Number: 46500 **Part Number:** D135751011

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	08/03/23
20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Pressure wash as per QSI 005	09-04-02
21.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 9:00 OVEN TEMPERATURE: 390° FINISH TIME: 9:30	M110939 BK 09.04.2
22.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	09-04-07
23.0	ALS71032130	Insert
	Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s) Insert Batch: M108606	
24.0	ALS41032225	Insert
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Insert Batch: M19393	
25.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 1- Install Wearplate &Ground Wire inserts as per Dwg D3507.	09-04-02

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 9:16:23 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** EC 135 SKIDTUBE ASSEMBLY

Job Number: 46500 **Part Number:** D135751011

Job Number:

Seq. #:	Machine Or Operation:	Description :
26.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP Inspect Inserts	094407 (1) good N Tight
27.0	AN526C1032R10	Screw
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Screw batch M1080G2	
28.0	D29653	Cap
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Cap Batch: B46582	
29.0	D2965	Cap, 105 Skidtube
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Cap Batch: B41523	
30.0	D35081	Wearplate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARPLATE Batch: B42973	
31.0	D35083	Wearplate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARPLATE Batch: B42250	
32.0	D35085	Wearplate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARPLATE Batch: B42251	09-04-07 (X)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 9:16:23 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** EC 135 SKIDTUBE ASSEMBLY

Job Number: 46500 **Part Number:** D135751011

Job Number:

Seq. #:	Machine Or Operation:	Description :
33.0	D35087	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B441518 YL

34.0	D35581	Gasket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: 1342533 YL

35.0	D35583	Gasket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: B456061 YL

36.0	D35585	Gasket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: B43244 YL

37.0	D35587	Gasket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: 1343245 YL

38.0	NAS1611010	O-RING

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
O-RING
batch: M110715 YL X

39.0	NAS1611013	O-RING

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
O-RING
batch: M106513 YL X 09-04-07 (X)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 9:16:24 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** EC 135 SKIDTUBE ASSEMBLY

Job Number: 46500 **Part Number:** D135751011

Job Number:

Seq. #:	Machine Or Operation:	Description :
40.0	NAS1611007	O-RING

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
O-RING
batch:_____

41.0	D3492041	Plug Assembly

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
PLUG ASSEMBLY
Batch: 1345561

42.0	D3492043	Plug Assembly

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
PLUG ASSEMBLY
batch B46407

43.0	D3492047	Plug Assembly

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
PLUG ASSEMBLY
Batch: 1328961

44.0	AN960C10L	washer

Comment: Qty.: 33.0000 Each(s)/Unit Total : 33.0000 Each(s)
Washer
Batch: M110916

45.0	AN3C4A	BOLT

Comment: Qty.: 31.0000 Each(s)/Unit Total : 31.0000 Each(s)
BOLT
Batch: M111193

46.0	AN3C5A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M110916 09-04-07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** EC 135 SKIDTUBE ASSEMBLY

Job Number: 46500 **Part Number:** D135751011

Job Number:

Seq. #:	Machine Or Operation:	Description :
47.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"
A/R 241 Sika Flex Batch: M111087
Exp Date: 10/20

3-Install Wearplates as per Dwg D3507 ,
Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Scews where indicated on Dwg(Note #6)
A/R 241 Sika Flex Batch: M111087
Exp Date: 10/10

GL 09-04-07 (XU)

4-Install Plug assemblys as per Dwg D3507.

5- Wing Walk as per Dwg D3507 and QSI 005 4.4 M111013 GL 09-04-09 (XU)

48.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP S 08/04/08 (XU)

49.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

50.0	D35121	Wearplate

S **Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WEARPLATE
Batch: 44642.

SS 09/04/09 (XU)

51.0	AN960JD10L	Washer

S **Comment:** Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer
Batch: M109632

SS 09/04/09 (XU)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 9:16:24 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** EC 135 SKIDTUBE ASSEMBLY

Job Number: 46500 **Part Number:** D135751011

Job Number:

Seq. #:	Machine Or Operation:	Description :
52.0	AN3C4A	BOLT

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
BOLT
BATCH: M111193 09/04/09 (X1)

53.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS 09/04/09

54.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D135-751-011
Location: 82
PPP Rev: B 9/4/9 SO

55.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 09/04/14

Job Completion

MF 09-04-09

B46500

Dart Aerospace Ltd

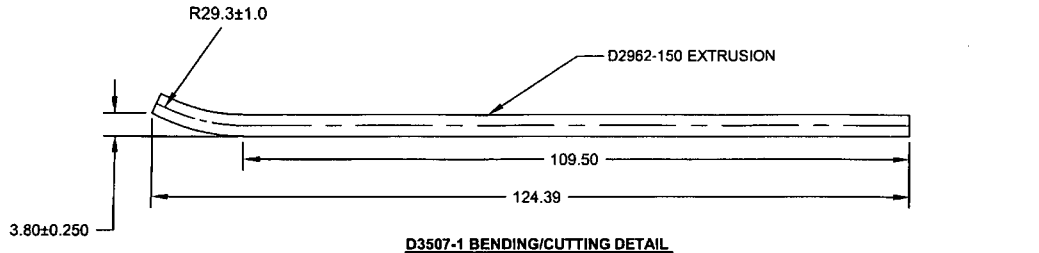
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

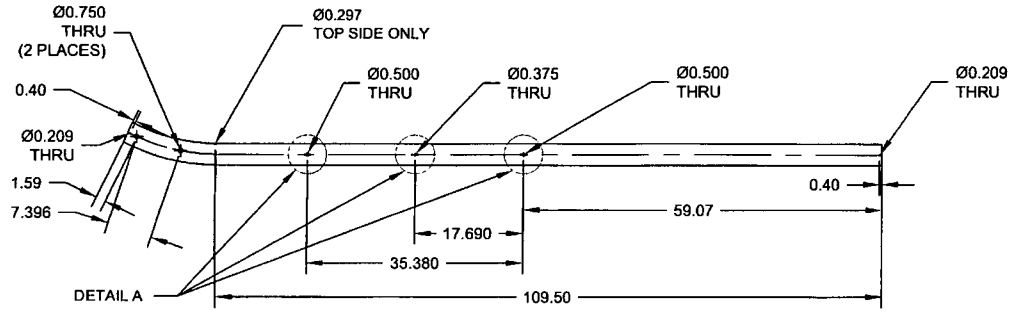
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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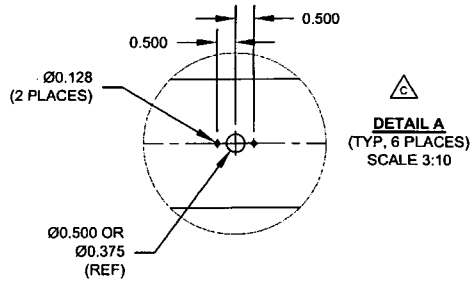
NOTE: Date & initial all entries



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



△C
DETAIL A
(TYP, 6 PLACES)
SCALE 3:10

Qty	Part Number	Description	
X	D3507-041	SKIDTUBE ASSEMBLY	
1	D2962-150	EXTRUSION	
1	D2965	CAP	
1	D2965-3	CAP	△B
4	D3492-041	PLUG ASSEMBLY	
4	D3492-043	PLUG ASSEMBLY	
2	D3492-047	PLUG ASSEMBLY	
2	D3504-1	CROSS BOLT SPACER	
1	D3504-3	CROSS BOLT SPACER	
2	D3504-5	CROSS BOLT SPACER	△C
1	D3505-1	WEB	
4	D3506-1	DOUBLER	
2	D3506-3	DOUBLER	
1	D3508-1	WEARPLATE	
1	D3508-3	WEARPLATE	
1	D3508-5	WEARPLATE	
1	D3508-7	WEARPLATE	△B
1	D3558-1	GASKET	△B
1	D3558-3	GASKET	△B
1	D3558-5	GASKET	△B
1	D3558-7	GASKET	△B
38	AELS-1032-130	INSERT	
1	AELS-1032-225	INSERT	
31	AN3C4A	BOLT	△B
2	AN3C5A	BOLT	△C
2	AN526C1032-10	SCREW	△C
33	AN960C10L	WASHER	△C
12	MS20601AD4W3	RIVET	

RELEASED
07-11-16

GENERAL NOTES:

1) FINISH:
 CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
4) WELDING TO BE DONE PER DART QSI 004
5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/ -291 ADHESIVE PER DART QSI 015 AFTER BENDING
6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

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REV.	DESCRIPTION	BY	DATE
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	JTC	PORT HADLOCK, WA
CHECKED	PH	DRAWING NO. D3507 — REV. C — SHEET 1 OF 2
MFG. APPR.		
APPROVED		TITLE: EC 135 SKIDTUBE — SCALE: NTS
DE APPR.		
DATE	07.09.19	

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Dart Aerospace Ltd

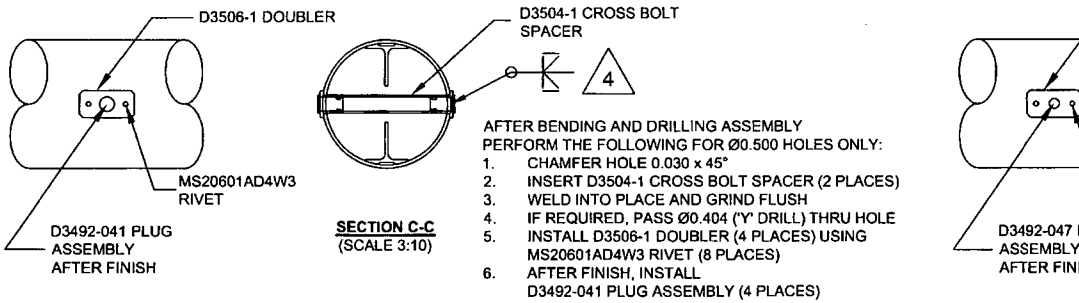
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

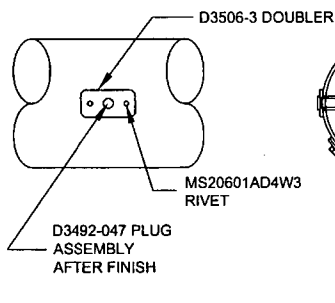
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

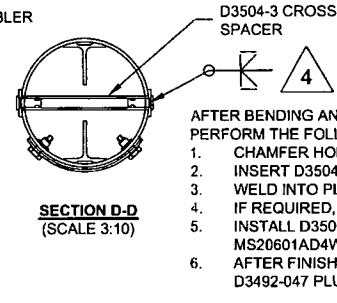
NOTE: Date & initial all entries



SECTION C-C
(SCALE 3:10)

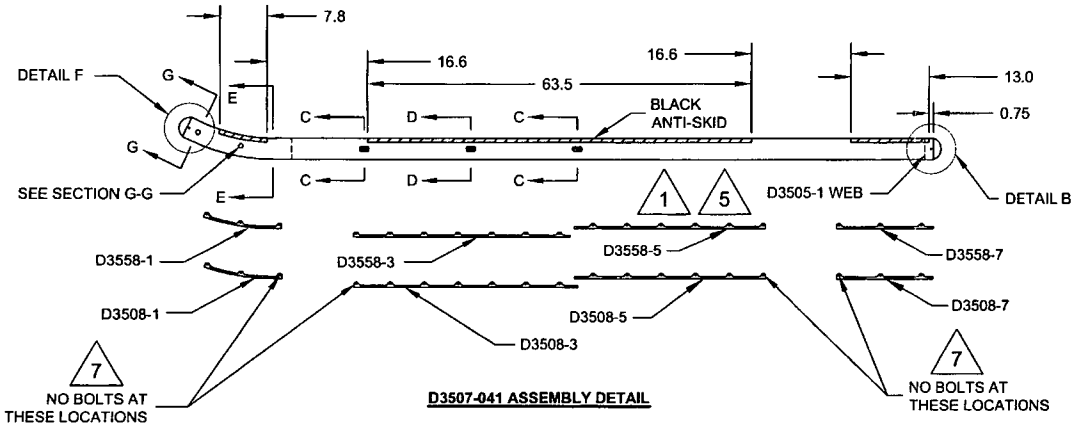
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3504-1 CROSS BOLT SPACER (2 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. IF REQUIRED, PASS Ø0.404 ('Y' DRILL) THRU HOLE
5. INSTALL D3506-1 DOUBLER (4 PLACES) USING MS20601AD4W3 RIVET (8 PLACES)
6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY (4 PLACES)



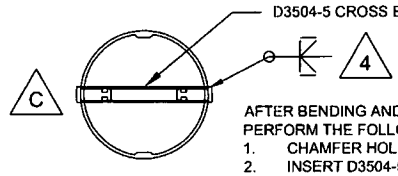


SECTION D-D
(SCALE 3:10)

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3504-3 CROSS BOLT SPACER (1 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. IF REQUIRED, PASS Ø0.277 ('J' DRILL) THRU HOLE
5. INSTALL D3506-3 DOUBLER (2 PLACES) USING MS20601AD4W3 RIVET (4 PLACES)
6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY (2 PLACES)

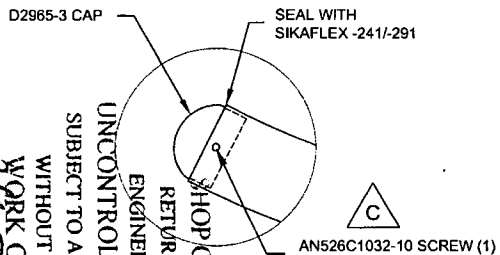


D3507-041 ASSEMBLY DETAIL

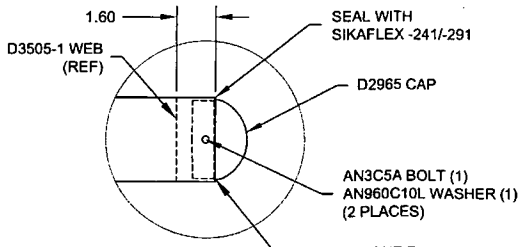


SECTION G-G
(SCALE 3:10)

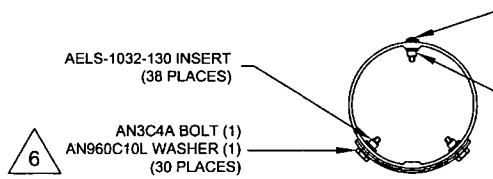
AFTER BENDING AND DRILLING
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3504-5 CROSS BOLT SPACER (2 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY (4 PLACES)



DETAIL F
(SCALE 1:5)



DETAIL B
(SCALE 1:5)



SECTION E-E
(SCALE 3:10)

RELEASED
07.11.19

DESIGN		**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D3507 — REV. C — SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE: EC 135 SKIDTUBE — SCALE: 1:20
DE APPR.		
DATE: 07.09.19		

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

NO. 179

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B41333
Part number: A135 75011
Description: Skid tube
Welding Process: Tig[✓] Mig[]
Base materiel: Alum
Current: AC[✓] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓]	fail[]
Penetration:	pass[✓]	fail[]

UNACCEPTABLE

Cracks:	pass[]	fail[]
Undercut:	pass[✓]	fail[]
Pin holes:	pass[✓]	fail[]
Overlap (cold lap)	pass[]	fail[]
Porosity (surface):	pass[✓]	fail[]
Coloration:	pass[✓]	fail[]

Qualifier David Dyad **Date of Test Coupon** 08/10/22

Welder Barclay Elliott **Date of Test Coupon** 08/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld